Work Orde		0998		*10	109	98*						Page 1
Item ID: Revision ID: Item Name: Start Date: Required Date:	5/10/13	g Assembly, Fwd  Start Qty: 2.00  Req'd Qty: 2.00	*2* *2*	Accept	*	N900 Cust Item I Customer:		100	<b>)*</b> s	Setup Stai	I VI	S1* S2*
Approvals:		an: MUJ	Date: 13-08-0	VTooling:  SPC (Y/N):			nte:		F	Run Sta Sto	I/I	R1* R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	S	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr										;
D4148	D											
*100 *100* Small Fab Small Fab		<b>Memo</b> 1- Assemb	le as per dwg	0.00					da			JS,
*110 *110* QC Quality Control	·	QC5- Inspect part com	pleteness to step on W/O	0.00 PS. (	; 6 6	•			٥		-	· · · · · · · · · · · · · · · · · · ·
*120 *120 *Packaging Packaging		Identify as per dwg & S	Stock Location: <u>5746</u>	0.00				SP	2×		Y.hO.	13-06-6

												DQA:	D	ate:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE		QA Closed:	D:	ate:	
Work Ord	or.	<del></del>			-	DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
Part   NCR	No.					Rework Scrap Use-as-is Work Order Update  Rework Skid-tube Machining Small Fab Thermoforming Large Fab Composite						-	Water Je d. Eng. Coor re/Packaging Supplie		Engineering Quality Other
Root					Descri	ption of work order update		Initial	Ac	tion		Sign &			
Cause		Date	Step	Qty	(	or Non-conformance	Ct	nief Eng	Desc	ription		Date	Verification	on	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved							- A111	T CATE	CORV	,					
Land	: (			<del></del>	·	General	AUI	.I CATE	JURY	· · · · · · · · -					
Latio		Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples in	Crimped at n Strip in n Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/ nance led	'Unclear		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
1	1	Torque V	vaves in E	extrusion	1	Drawing	1	JOut of C	Calibration						

Out of Sequence

Outside Dimensions

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Turning Sequence

Wave/Twist in Tube

Finish

Folio

DQA: \_\_\_\_\_ Date: \_\_\_\_

NCR:	Yes		No
INC.D.	160	,	144

## WORK ORDER NON-CONFORMANCE / UPDATE

									QA Closed:	Date	<u> </u>
Work Orde	er:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N	 lo	- 4 1 1 - 1 - 1			Rework Scrap Use-as-is Work Order Update	Th	Skid-tube  Machining ermoforming Large Fab	Crosstube Small Fab Finishing Composite	-1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root			Ì	Descr	iption of work order update	Initia	ı A	Action	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief E	ing De	scription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material										·	
Setup							,				
Other											
Process		İ				1					
Supplier											
Training		٠.									
Unapproved			<u> </u>	<u> </u>					<u> </u>		
					F	AULT CA	TEGORY				· · · · · · · · · · · · · · · · · · ·
Landii	ng Gear				General				7	_	7
	Bendir	_			Bend	Gra	•		Ovalized		Pressure/Forced
		Not Conce	ntric to	o/s	BOM/Route	$\vdash$	dware		Over/Under	<b>├</b>	Temperature/Cure
,	Cracks				Broken/Damaged	<b>—</b>	ection incomplete	<del>-</del>	Part Incorre	<u> </u>	Weld
	_	d/Crimped		_	Burrs	<del></del>	ructions Incomplete	e/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs Contamination					$\vdash$	ntenance	<u></u>	Part Moved		
	Heat Treat Countersink					$\vdash$	abeled		Positioned V		7
	Inspection Strip in Tube Cut Too Short						read	L_	Power Loss/	Surge	Other
	Ripples in Bend Drill Holes					Offs					<u> </u>
		Waves in		n	Drawing	-	of Calibration -				
		g Sequence			Finish	$\vdash$	of Sequence				
	Wave/Twist in Tube Folio					Out	side Dimensions				

## **Picklist Print**

April-30-13 2:37:55 PM

Work Order ID:

100998

Parent Item:

D4148-041

Parent Item Name:

Crosstube Lug Assembly, Fwd

**Start Date: 5/10/13** 

Required Date: 5/10/13

Page 1

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:A 10.06.24 new issue DD verf:EC

IPP Rev:B 10.07.22 as per revB DD verf:JLM IPP Rev:C 10.10.29 as per revC DD verf:EC IPP REV:D 11.03.02 AS PER DWG REV.D DD VERF:EC

Component Item ID/ tem Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Locatio		Route Seq ID	Unit of Measure	Qty. on Hand	Qty per Kit	Total Qty	Qty Issured	Date Jssued/	Status
MS21043-3		Purchased	No			100	Each	2,304.0000	4	4		2/2	
lut									C	<	JX.	S/03	128
				Location		Loc Oty	Lo	oc Code			/	/ /	f :
				FG		80							
					103691	80							
				GA		106							!
					123899	106							
				ST315		2118							
					123899	196				·	_		
					124555	1922				<u>/</u>			/ /
IS21043-4		Purchased	No			100	Each	356.0000	1	6	9/	8-2/0	//,
ut									(100 miles 100 miles			1/5/0	) <sub> </sub>   \( \alpha \)
				Location		Loc Qty	<u>L</u> e	oc Code	•				
				FG		36				/			į
					104603	36							
				GA		44				<i>k</i> .			
					121652	44				44			
				ST315		276					М	12580	7/2
					121162	25					1	10 5	′ 🖰
					123021	220							
					123525	29						/	. 1
					123900	2					01		
2690-6 anyard Assembly		Manufactured	No			100	Each	24.0000	1	2		13/0	5/28
ang aca 13550mong				Location	1	Loc Qty	L	oc Code					
				ST014	•	24					•	,	,
				2.311	94775	9							ı
					95935	1		-					
					99056	4				1			
					99808	10				EL.			

DQA:	Date:	
******	-	

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

	•									QA Closed:	Dat	e:	
Work Ordei	֥				DISPOSITION			-	AGAINST DE	PARTMENT	/PROCESS		
Part No					Rework Scrap Use-as-is		í	Skid-tube Machining	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging		neering Quality Other
NCR N	o				Work Order Update			Large Fab	Composite	ince/stor	Supplier		
Root				Descri	ption of work order update	Ini	itial	Ad	ction	Sign &			
Cause	Date	Step	Qty	(	or Non-conformance	Chie	ef Eng	Desc	cription	Date	Verification	ı Qo	Inspector
Doc/Data	<b>`</b>												
quip/Tooling	$\overline{}$	]											
Operator													
Material						1						1	
Setup		]				:		:					•
Other													
Process		l											
Supplier 🔪 📗						1							
Fraining [												İ	
Jnapproved													
					F	AULT	CATE	GORY					
Landin	g Gear				General					-	-		
	Bending				Bend		Grain			Ovalized	ļ.	Pressu	re/Forced
	Centre No	ot Conce	ntric to (	o/s	BOM/Route		lardwa	re		Over/Under	tolerance	Tempe	rature/Cure
Ĺ	Cracks				Broken/Damaged	<u></u> "	nspecti	on Incomplete		Part Incorred	et [	Weld	
	Crushed/	Crimped			Burrs	L. II	nstruct	ions Incomplete,	/Unclear	Part Lost/Mi	ssing	Wrong	Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved			
	Heat Trea	at			Countersink		∕Iislabe	led		Positioned V	Vrong		
	Inspection	n Strip in	Tube		Cut Too Short		∕lisreac	I		Power Loss/	Surge	Other	
	Ripples in	Bend			Drill Holes		Offset						
	Torque W	/aves in E	xtrusio	n 🗀	Drawing		Out of 0	Calibration					
	Turning S	equence			Finish		Out of S	Sequence					
	Wave/Tw	ist in Tul	эе		Folio		Dutside	Dimensions			·		

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April-30-13 2:37:55 PM

Work Order ID:	100998								;
Parent Item:	D4148-041						Start	Date: 5/10/13	Required Date: 5/10/13
Parent Item Name:	Crosstube Lug As	ssembly, Fwd					Start	t Qty: 2.00	Required Qty: 2.00
D3910-1 Crosstube Lug		Manufactured	No		100	Each	8.0000	1	2 33/05
				Location	Loc Qty		Loc Code		
				ST464	. 8				<u></u>
				81474	2				
	· .			89772	1				
				93755	5			_d_	- ()// / :
D4091-1 Mounting Lug		Manufactured	No		100	Each	21.0000	1	2/////3/05
viounting Dug				<u>Location</u>	Loc Qty		Loc Code	<u> </u>	7-1
•				ST144	21			<b>a</b>	//
-				97517	21			_ 2"	
D4148-1		Manufactured	No		100	Each	6.0000	2	4 5//( /
Crosstube Lug Plate, Fw	'd								L/U/3/ps
				Location	Loc Oty		Loc Code		
				ST145	6				
				85753	2				<u> </u>
				97907	4				- / /
D4148-3		Manufactured	No		100 .	Each	14.0000	1	2
Stud Receiver, Lower					,			( ** ** ** ** ** ** ** ** ** ** ** ** **	$-\sqrt{3/05}$
				Location	Loc Qty		Loc Code		// . / _ /
				ST145	14		·		_ //
				97610	8				
				97611	6				- 01.
D4148-5		Manufactured	No		100	Each	13.0000	1	2 / / / /
Eyebolt Stud							•	<del></del>	JU13/03
		•		Location	Loc Oty		Loc Code		
				ST145	13				
				97587	1				
				99176	12				

												DQA:	Da	ite:	
NCR:	/es	/ No				WORK ORDER NON-C	100	NFORM	MANCE / UP	DATE			_		
									-			QA Closed:	Da	ite:	
Work Orde	er:					DISPOSITION				AGAINST [	ÞΕ	PARTMENT	/PROCESS		•
Part N	-					Rework Scrap Use-as-is		ı	Skid-tube Machining noforming	Crosstube Small Fab Finishing		4	Water Jet d. Eng. Coor. e/Packaging		Engineering Quality Other
NCR I	No.					Work Order Update	]		Large Fab	Composite			Supplier		
Root					Descri	ption of work order update	l	Initial	Ac	tion		Sign &			
Cause		Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verificatio	n	QC Inspector
Doc/Data		*													Í
Equip/Tooling	`	. ,													
Operator							İ								
Material			•												
Setup															
Other								i							
Process												·			
Supplier						•									
Training															
Unapproved									:						
						F	AUL	LT CATE	GORY						
Landi	ng G	Sear				General		_		_		_			_
		Bending				Bend		Grain				Ovalized		L	Pressure/Forced
		Centre No	ot Concei	ntric to	O/S	BOM/Route		Hardwa	re			Over/Under	tolerance		Temperature/Cure
+.1		Cracks				Broken/Damaged		Inspecti	on Incomplete			Part Incorred	:t	L	Weld
Crushed/Crimped Burrs						Burrs	Instructions Incomplete/Unclear			Part Lost/Missing			Wrong Stock Pulled		
Cuffs Contamination						Contamination	Maintenance				Part Moved			_	
		Heat Trea	ıt			Countersink				Positioned Wrong		_			
	Inspection Strip in Tube Cut Too Short						Misread				Power Loss/:	Surge		Other	

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

F

Drill Holes

Drawing

Finish

Folio

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

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April-30-13 2:37:55 PM

Work Order ID: Parent Item:	100998 D4148-041						C+~+ 1	Date: 5/10/13	Required Date: 5/10/13
Parent Item Name:	Crosstube Lug Ass	eambly Furd						Qty: 2.00	Required Qty: 2.00
	Clossiude Lug Ass	•						•	Required Qty: 2.00
AN3C12A Bolts		Purchased	No		100	Each	208.0000	2	45/3/05/28
				Location	Loc Qty		Loc Code		
	,			ST351	208				1
				123648	5				<u> </u>
				124561	201			4	
				124858	2				- // / /
<b>AN4C13A</b> BOLT		Purchased	No		100	Each	128.0000	3	6/3/05/08
				<b>Location</b>	Loc Oty		Loc Code		
	•			ST356	3				
				123900	3				<del></del>
				ST514	123				
				124805	123			6	<del>_</del>
				ST516	2				
				124215	2				_
MS17984-C413		Purchased	No		100	Each	10.0000	1	$\overline{}_{2}$
PIN, QUICK RELEASE								<u> </u>	(1) 3 /06/1
	,			Location	Loc Qty		Loc Code		
				ST332	2				
				118612	2				M12582 7
				ST508	8				•
				124231	8			<del> </del>	
<b>MS20615-4M18</b> Rivet		Purchased	No		100	Each	219.0000	8	16 3/05
				Location	Loc Oty		Loc Code		
				GA	7				_ //
				122452	7			16	
				ST312	212				
				124331	115				<del></del>
				125162	97				_

				DQA:_	Date: _	
NCR:	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE			

											QA Closed:	Date:	
Work Orde	r:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	Part No. Suse NCR No. Work Order Up								Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	Ī	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator													
Material													
Setup	_												,
Other													
Process	_												
Supplier	_												
Training	4												
Unapproved	.							TCATE	CORY				
<u> </u>							AUL	T CATE	GORY	·····			
Landin		ending				<b>General</b> Bend		Grain			Ovalized		Pressure/Forced
h	_	enuing Centre No	t Cancar	stric to C		BOM/Route	_	Hardwa	uro.	<del>                                     </del>	Ovanzeu Over/Under	toloranco	Temperature/Cure
	—-	racks	i Concer	itile to C	″³   <u> </u>	Broken/Damaged	-		ion Incomplete	<u> </u>	Part Incorred	<b>├</b>	Weld
}	_	Trushed/0	rimped		-	Burrs	_		ions Incomplete/	Unclear	Part Lost/Mi		Wrong Stock Pulled
1		Cuffs	cimped		-	Contamination	$\vdash$	Mainte	•		Part Moved	331116 <u> </u>	Tanton's Stock Lanca
	<b>├</b>					Countersink	-	Mislabe		<del> </del>	Positioned V	/rong	
}		nspection		Tube		Cut Too Short	$\vdash$	Misread		<b>⊢</b>	Power Loss/	_	Other
	_	Ripples in			-	Drill Holes	-	Offset	-		1	· _	
	_	orque W		xtrusion		Drawing	-		Calibration				
	Turning Sequence Finish					_		Sequence		· · · · · · · · · · · · · · · · · · ·		<del> : </del>	
1 1	Wave/Twist in Tube					Folio	$\vdash$		Dimensions				

April-30-13 2:37:56 PM

Work Order ID:	100998				
Parent Item:	D4148-041	•		<b>Start Date:</b> 5/10/1	3 Required Date: 5/10/13
Parent Item Name:	Crosstube Lug Assembly, Fwd			Start Qty: 2.00	Required Oty: 2.00
NAS1149C0332R Washer	Purchased	No	100 Each	6,719.0000 4	8 9513/05/28
		<b>Location</b>	Loc Qty	Loc Code	
		FP001	264		
		123355	264		1
		ST292	3577		
		123248	18	-	
		123759	2747	<del></del>	<del>}</del>
		125268	812		
		ST517	2878		
		124580	2878		
NAS1149C0432R Washer	Purchased	No	100 Each	1,626.0000 6	12 /3/05/28
		<b>Location</b>	Loc Qty	Loc Code	
		ST292	1626		
		119124	6	<del></del>	
		122441	1620	/	

DQA: Date:
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**WORK ORDER NON-CONFORMANCE / UPDATE** 

NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS** DISPOSITION Work Order: Skid-tube Water Jet Engineering Rework Crosstube Quality Machining Prod. Eng. Coor. Small Fab Part No. Scrap Rec/Store/Packaging Thermoforming Other Use-as-is Finishing Work Order Update Large Fab Composite Supplier NCR No. Description of work order update Action Sign & Initial Root Description Chief Eng Verification QC Inspector Step or Non-conformance Date Date Qty Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Bend Grain Ovalized Pressure/Forced Bending Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Temperature/Cure Weld Broken/Damaged Part Incorrect Cracks Inspection Incomplete Crushed/Crimped Part Lost/Missing Wrong Stock Pulled Burrs Instructions Incomplete/Unclear Cuffs Contamination Maintenance Part Moved Countersink Mislabeled Positioned Wrong **Heat Treat** Cut Too Short Misread Power Loss/Surge Other Inspection Strip in Tube Ripples in Bend **Drill Holes** Offset Out of Calibration Torque Waves in Extrusion Drawing Out of Sequence Turning Sequence Finish

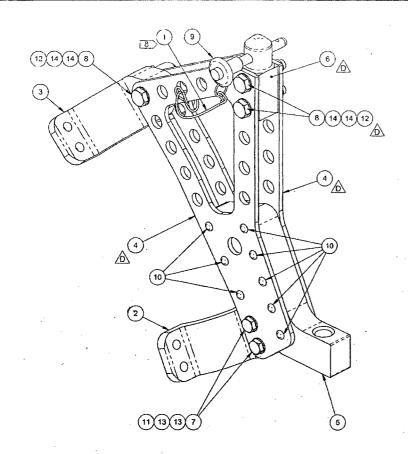
**Outside Dimensions** 

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Wave/Twist in Tube

Folio





## D4148-041 FWD X-TUBE LUG ASSY

NOTES: 1) MATERIAL: N/A

D

2) FINISH: NONE 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4148-041" PER DART QSI 044 6.1

8

8) ATTACH D2690-6 TO D4148-1 BY LOOPING AROUND A LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413

UNCONTRA

QTY -041

11

12

13

D4148-041

D3910-1

D4091-1

D4148-1

D4148-3 D4148-5

AN3C12A

AN4C13A

MS17984-C413 MS20615-4M18

NAS1149C0332R

NAS1149C0432R

MS21043C3 MS21043C4

COLUMN TELLS 100998 MUJ 13-05-02

FWD X-TUBE: LUG ASSY

FWD X-TUBE LUG PLATE

STUD RECEIVER LOWER

LANYARD

BOLT

BOLT

NUT

WASHER

WASHER

PIP PIN RIVET

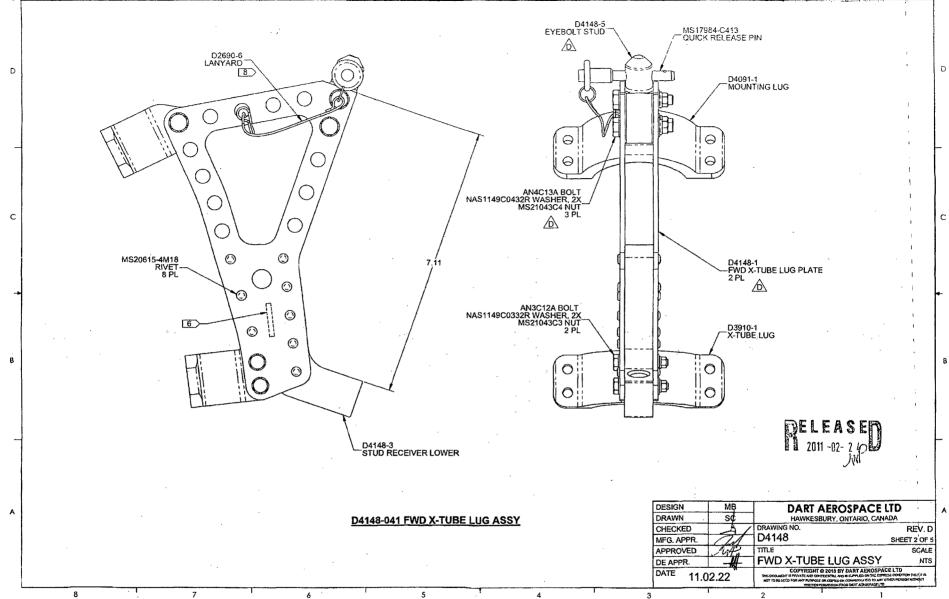
X-TUBE LUG

MOUNTING LUG

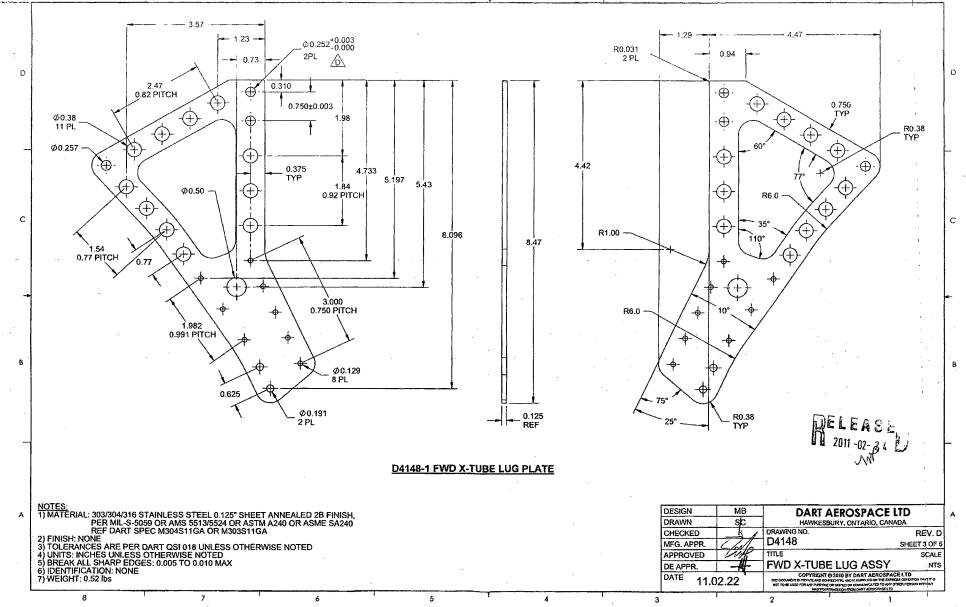
EYEBOLT STUD

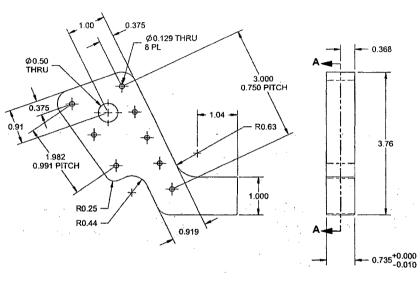
HOLE DIA CHANGED TO 0.252" (D8-3); HOLE DIA CHANGED TO 0.250" (C8-5); REPLACED OTY(2) AN3C12A, MS2104323 AND OTY(4) MS51149C0332R WITH OTY(2) AN4C13A, MS21043C4 AND OTY(4) NAS1149C0432R (U3-1,C4-2) 11.02.22 REDESIGNED D4148-1/-3 TO ADDRESS COMPATIBILITY ISSUES WITH D350-591 SHORT STEPS MB 10.10.12 ISSES WITH D35959 STUDY 151E7S
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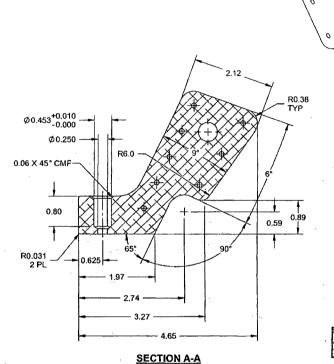
REV.		DESCRIPTION	51	DATE
DESIGN	MB	DART AEROSPACE LTD		TD D
DRAWN	sc	HAWKESBURY, ONTARIO		
CHECKED	1	DRAWING NO.		REV. D
VFG. APPR.	Call	D4148		SHEET 1 OF 5
APPROVED	Like	TITLE		SCALE
DE APPR.	-11	FWD X-TUBE LUG AS	SSY	NTS
DATE 11.0	02.22	COPYRIGHT © 2010 BY DART A THE DOCUMENT IN PROVIDE AND CONFEDENCE APPLED THE MAN PLANT OF THE COPY OF COPY OF COMPANY OF THE COPY OF C	ON THE EXPTE	SE DOPROMON THAT IT TO



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DESIGN DART AEROSPACE LTD sc DRAWN DRAWING NO. CHECKED REV. D D4148 SHEET 4 OF 5 MFG. APPR. TITLE APPROVED SCALE FWD X-TUBE LUG ASSY DE APPR. DATE 11.02.22

NOTES: 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276 REF DART SPEC M304B OR M303B

REF DART SPEC M304B OR W303B

2) FINISH: NONE

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 1.52 lbs

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**D4148-3 STUD RECEIVER LOWER** 

100918

1.38 REF Ø0.266 THRU R0.060 Ø1.00 --Ø0.250<sup>+0.003</sup> THRU TYP TYP ◬ G SYMM Ø0.700+0.000 -0.010 - 0.750<sup>+0.003</sup> CHAMFER 0.230 X 45° 0.310 0.735+0.010 0.350 **D4148-5 EYEBOLT STUD** 

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NOTES:
1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276 REF DART SPEC M304B OR M303B
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.27 lbs

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DESIGN	MB	DART AEROSPACE LTD		
DRAWN SC		HAWKESBURY, ONTARIO, CANADA		
CHECKED	1	DRAWING NO.	REV. D	
MFG. APPR.	Tool	7 D4148	SHEET 5 OF 5	
APPROVED	UF	TITLE	SCALE	
DE APPR.		FWD X-TUBE LUG ASSY	NTS	
DATE 11.0	02.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD  HIS DOCUMENT SPENIT, NO OUR ORTHUL BOY THE DEVENCE OF DEPOSITION THAT IT IS  NOT TO BE USED YOU ARE PROSECULATED OF COMMAND ASSESSED ASSESSED WITHOUT,  TO THE USED YOU ARE PROSECULATED ASSESSED ASS		

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